

Work Order ID 53674

November 12, 2009 8:17:37 AM



Page 1

Item ID: D3929-042

Accept



Setup Start



Revision ID: A

Stop



Item Name: Gusset Assembly

Start Date: 12/11/2009 Start Qty: 6.00



Cust Item ID:

Required Date: 19/11/2009 Req'd Qty: 6.00



Customer:

Reference:

Approvals:

Process Plan:

PL

Date: *07-11-12*

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3929	rev A								

100

0.00



Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3929

Dwg Rev: *A*

Prog Rev: *A*

2-Deburr if necessary

HB 9-11-12



110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

HB 9-11-12

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Item ID: D3929-042

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Item Name: Gusset Assembly

Start Date: 12/11/2009 Start Qty: 6.00



Cust Item ID:

Required Date: 19/11/2009 Req'd Qty: 6.00

Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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120

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

8 5.11.13

130

Pick Kit

0.00



Packaging

Memo

0.00

Packaging

50 09 11 17

140

0.00



Large Fab

Memo

0.00

Large Fab

Weld bushings D3907-1 as per dwg D3929

316L rod batch:

M108775

50 09 11 17 (8x)

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Item ID: D3929-042

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Setup Start



Revision ID: A

Item Name: Gusset Assembly

Stop



Start Date: 12/11/2009 Start Qty: 6.00



Cust Item ID:

Required Date: 19/11/2009 Req'd Qty: 6.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150 QC Quality Control	QC9- Inspect visual per QSI004- Fusion Welds Memo	0.00 0.00							
160 QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00							
170 Packaging Packaging	Identify as per dwg & Stock Location: <u>WA</u> Memo	0.00 0.00							

CP 09 11 17

27 09/11/17

(X) 8

SAD

09-11-18

(8)

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Item ID: D3929-042

Accept

Revision ID: A

Item Name: Gusset Assembly

Start Date: 12/11/2009 Start Qty: 6.00

Required Date: 19/11/2009 Req'd Qty: 6.00

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

180

QC21- Final Inspection - Work Order Release

0.00

QC

Memo

0.00

Quality Control

09/11/18
ME
09-11-18

Picklist Print

November 12, 2009 8:17:41 AM

Page 1

Work Order ID: 53674

Parent Item: D3929-042RevA

Parent Item Name: Gusset Assembly



Comments:

Start Date: 12/11/2009

Required Date: 19/11/2009

Start Qty: 6.00

Required Qty: 6.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M304S11GA 		Purchased	No			100	sf	128.7100	2.8421	4.		
304/316 0.125 Sheet											13-11-12	

Warehouse
Location

Loc Qty

Loc Code

Main Warehouse

MAT

128.7099979

111018

0.70999789

112663

128

111018

Ⓢ

D3907-1RevA

Manufactured

No

130

Each

27.0000

12.0000



Sp 09.11.17

Bushing

Warehouse
Location

Loc Qty

Loc Code

Main Warehouse

ST

27

53138

27

16 x ✓

ITEM	QTY -041	QTY -042	P/N	DESCRIPTION
1	X		D3929-041	GUSSET ASSEMBLY
2		X	D3929-042	GUSSET ASSEMBLY
11	2	2	D3907-1	BUSHING
12	1	1	D3929-1	SUPPORT GUSSET

SHOP COPY
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UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ON
NO. 53674
BA 09-11-12

D3929-041 GUSSET ASSEMBLY

D3929-042 GUSSET ASSEMBLY

RELEASED
09/04/12

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3929-04X" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.73 lbs EACH
- 8) WELDING: PER DART QSI 004

A	NEW ISSUE	MB	09.04.03
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	09.04.03		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO.
D3929

REV. A

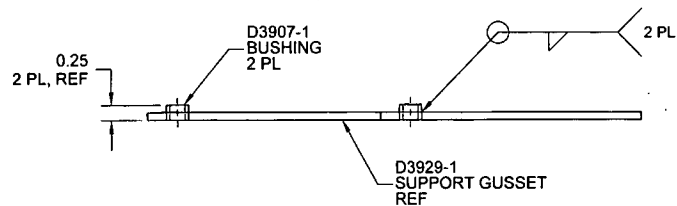
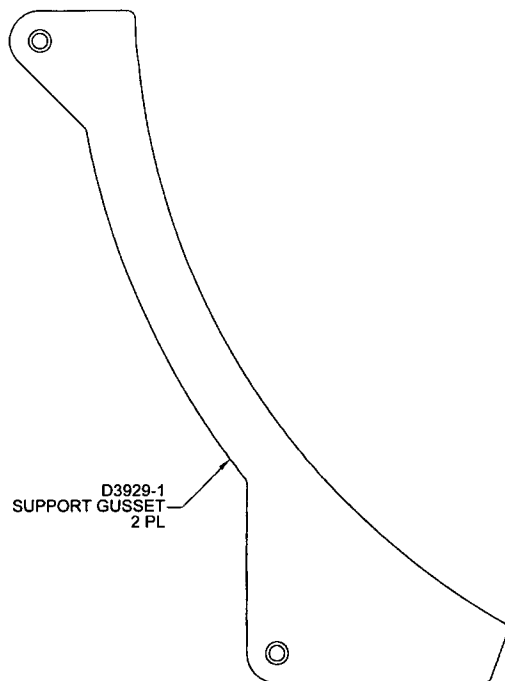
SHEET 1 OF 3

TITLE
GUSSET ASSEMBLY

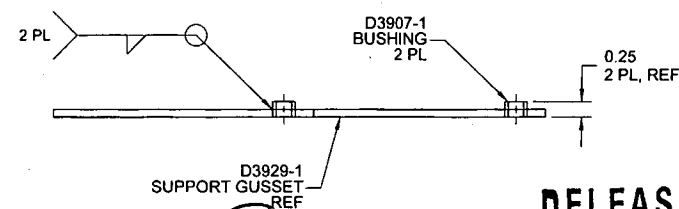
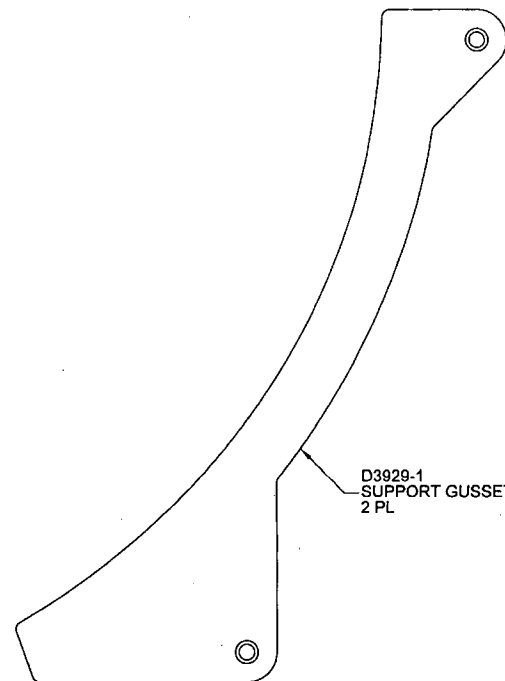
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NTS

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w/o 53674



D3929-041 GUSSET ASSEMBLY

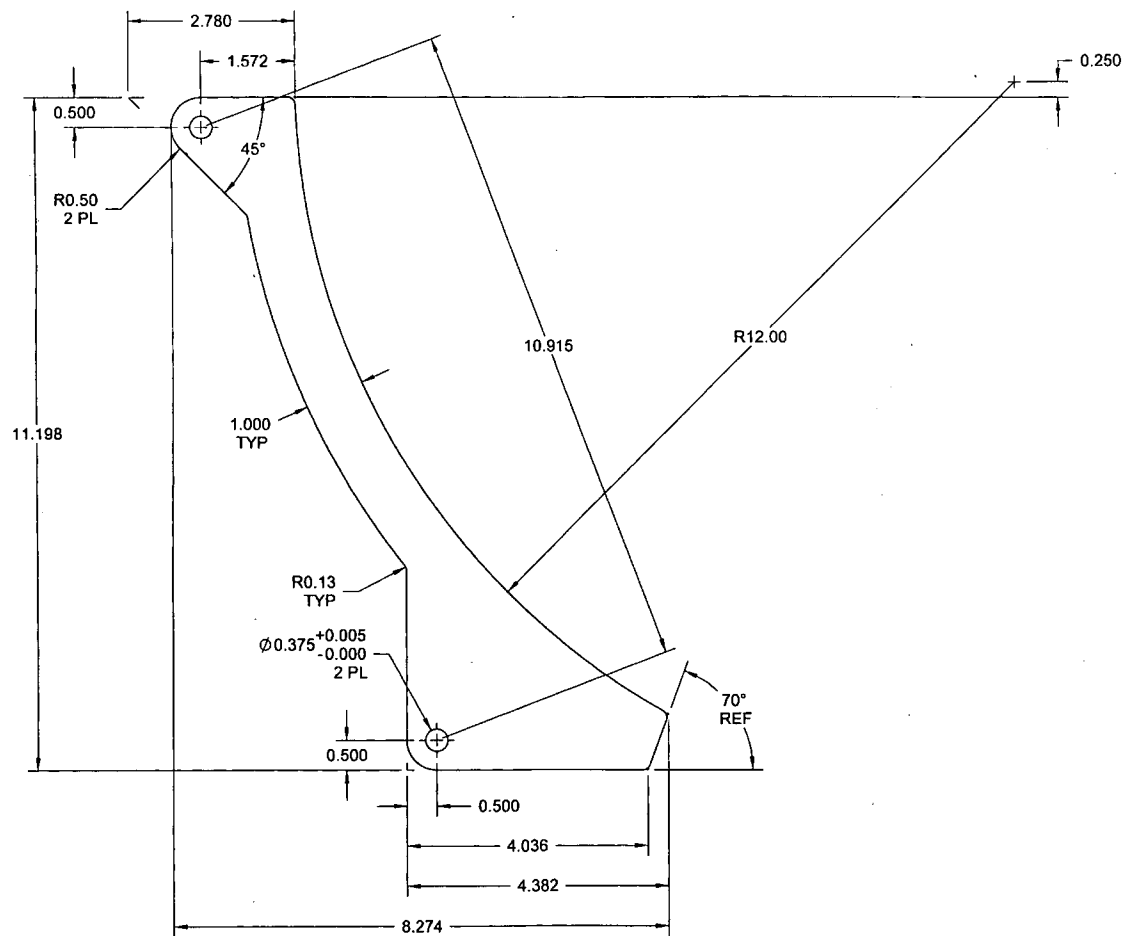


D3929-042 GUSSET ASSEMBLY

RELEASED
09/04/22

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W/053674



D3929-1 SUPPORT GUSSET

RELEASED
9/04/22 JND

- NOTES:
- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET PER AMS 5513 OR 5524
11 GAUGE (0.125 THICK)
REF. DART SPEC. M304S11GA
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 0.72 lbs

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